

Work Order ID 82734

April-05-12 12:56:59 PM

82734

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Item ID: D412-724-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Head Rest Assembly, Center

Stop ***NS2***

Start Date: 05/04/2012 Start Qty: 4.00

Required Date: 20/04/2012 Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: ML5

Date: 12/04/05 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
N/A	Rev N/A								
100		0.00							
100	DOCUMENT CONTROL								
DC		0.00							
Document Control	Memo								
	If D412-724-041 is a W/O on it's own, Photocopy bluefile and create labels per PPP D412-724-041 CHG001								
110	Pick Kit	0.00							
110									
Packaging		0.00							
Packaging	Memo								
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC		0.00							
Quality Control	Memo								

Sidolob

2x

SP
12-7-5

Sidolob

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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82734

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Item ID: D412-724-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Head Rest Assembly, Center

Stop ***NS2***

Start Date: 05/04/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 20/04/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00

130

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-724-041 Location: _____ PPP Rev: A

2x

SP
12-7-6

140

0.00

140

QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

CK 12/7/9

ME
12-07-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 82734

82734

Parent Item: D412-724-041

D412-724-041

Parent Item Name: Head Rest Assembly, Center

Start Date: 05/04/2012

Required Date: 20/04/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A04.09.08New IssueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN525-10R6		Purchased	No			120	Each	169.0000	4	16	12		

AN525-10R6
Screw

Location	Loc Qty	Loc Code
ST345	143	
120308	18	
120833	25	
120910	100	
ST346	26	
118757	23	
119309	3	

D3303-041
D3303-041
Head Rest

Manufactured No 120 Each 1.0000

Location	Loc Qty	Loc Code
ST186	1	
73224	1	

D3304-041
D3304-041
Tube Assembly

Manufactured No 120 Each 5.0000

Location	Loc Qty	Loc Code
ST186	5	
54438	3	
79840	2	

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12-7-4.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

3.0 INSTALLATION PROCEDURE

To install a Dart Head Rest Assembly:

- 3.1 If installed, remove the existing Head Rest Assembly by pulling the quick release pin that attaches it to the seat. Make note of the installation position (if applicable).
- 3.2 Inspect the seat for damage in the vicinity of the Head Rest Assembly. Consult the Aircraft Maintenance Manual for disposition if damage is observed.
- 3.3 If only replacing the Head Rest with the equivalent Dart D3303-041 Head Rest, separate the existing Head Rest from the existing Tube Assembly by undoing 4 screws. Re-assemble D3303-041 Head Rest with existing Tube Assembly by installing 4 screws and tightening to 15-25 in lb.
- 3.4 If only replacing the Tube Assembly with a Dart D3304-041/-043/-044 Tube Assembly, separate the existing Head Rest from the existing Tube Assembly by undoing 4 screws. Re-assemble existing Head Rest with Dart D3304-041/-043/-044 Tube Assembly by installing 4 screws and tightening to 15-25 in lb.
- 3.5 Slide the new or modified Head Rest Assembly into the seat tube and lock in place at the same location that the old Head Rest Assembly was installed (if applicable) using the quick release pin. Ensure pin is properly engaged.

4.0 WEIGHT AND BALANCE

There is negligible weight change associated with the installation of the Dart Head Rests.

5.0 PARTS LIST

QTY -011	QTY -041	QTY -043	QTY -044	Part Number	Description
X				D412-724-011	Dart Replacement Head Rest Kit, for 205/212/412
2	X			D412-724-041	Head Rest Assembly, Center
1		X		D412-724-043	Head Rest Assembly, LH
1			X	D412-724-044	Head Rest Assembly, RH
	1	1	1	D3303-041	Head Rest
	1	1	1	D3304-041	Tube Assembly
		1		D3304-043	Tube Assembly
			1	D3304-044	Tube Assembly
	4	4	4	AN525-10R6	Screw

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Run Start ***NR1***Stop ***NR2***Approvals: Process Plan: *MCS*Date: *12/04/05* Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr Revision Nbr

N/A Rev N/A

100

DOCUMENT CONTROL

100

DC

Memo

If D412-724-041 is a W/O on it's own, Photocopy bluefile and create labels per
PPP D412-724-041 CHG001

Document Control

110

Pick Kit

110

Packaging

Memo

Packaging

120

QC4- 100% Inspect kits for completeness

120

QC

Memo

Quality Control

